

Work Order ID 69405

Tuesday, May 10, 2011 3:24:41 PM



Page 1

Item ID: D3262-041

Accept



Setup Start



Revision ID:

Item Name: Canister Assembly

Stop



Start Date: 5/10/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:



Date: 110510

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

X

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInspec.
Stamp

Draw Nbr	Revision Nbr
D3262	Rev E

100



Weld per dwg A/R Aluminum rod Batch: 117456 0.00

Large Fab

Large Fab

Memo

0.00

2 + 0 BE 11/06/16

Large Fab

Weld canister assembly as per Dwg D3262 using DT8739 to align fillings.

110



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Quality Control

Memo

0.00

AS 11.06.16 (2)

120



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

S. W. 1.0

(2)

W/O:		WORK ORDER CHANGES							
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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

2x Ø M-11/06/16

Hand Finishing

140



Powdercoat

Powder Coating

M 116964

White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

****Ensure to mask threads ****
 START TIME: 3:20 00
 OVEN TEMPERATURE: 320 0F
 FINISH TIME: 4:10

2x Ø M-11/06/16

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

2x Ø M-11/06/16

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Page 3

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Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 44

0.00

11/16/16 SP 2

Packaging

Memo

0.00

Packaging

170



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/16/16 SP

MF
11-06-16

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NOTE: Date & initial all entries

Picklist Print

Page 1

Tuesday, May 10, 2011 3:24:48 PM

Work Order ID: 69405



Parent Item: D3262-041



Parent Item Name: Canister Assembly

Start Date: 5/10/2011

Required Date: 5/16/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP C□05.03.10□Removed P/O for liquid penetrant
inspection□KJ/JLM□
Rev:D as per ECN10-571 DD 10.05.10 verified :EC

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3262-1



Manufactured

No

100

Each

3.0000

1

2



Tube

Location	Loc Qty	Loc Code
----------	---------	----------

LG002

3

59740

1

63601

2

D3262-3



Manufactured

No

100

Each

6.0000

2

4



Cap

Location	Loc Qty	Loc Code
----------	---------	----------

LG002

6

63599

6

4



3/10/10
B70738 x2

3/10/10
B70738

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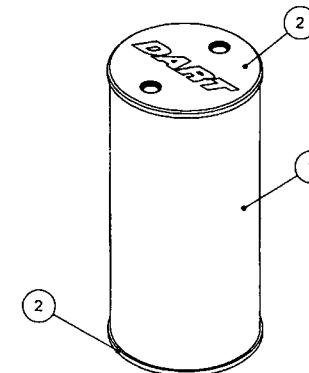
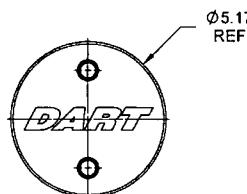
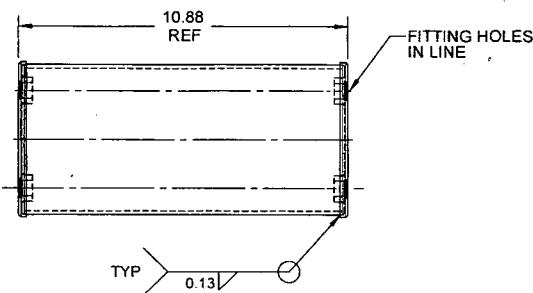
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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *104105*
07/11-05-10

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3262-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP



D3262-041 CANISTER ASSEMBLY

RELEASED
2010-05-07
MS

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.51 lbs
- 8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS

E	0.25 WAS 0.45 (ZN C7-4, C7-5); 0.13 WAS 0.33 (ZN B7-4, B7-5). ADD DIMENSION (ZN B1-4, D1-5, B1-5)	RF	10.05.03
D	ADD D3262-043-5 (ZN B5-2; B5-5); REVISE DIMENSIONS TO EQUAL TOOL DIMENSIONS (ZN B2-4; C2-4) PER CAR 09-004	RF	09.12.30
C	Ø5.165 WAS Ø5.190	RF	06.08.31
B	ADD PRESSURE TESTING OPTION	MB	05.02.14
A	NEW ISSUE	RF	04.05.06
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>MS</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>MS</i>	D3262	SHEET 1 OF 5
APPROVED	<i>MS</i>	TITLE	SCALE
DE APPR.	<i>MS</i>	FUEL PURGE CANISTER	NTS
DATE	10.05.03	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY INFORMATION OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3262-043	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-5	CAP

D3262-043 CANISTER ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY TO 0.010 MAX
- 7) WEIGHT: 2.50 lbs
- 8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
- 9) WELD CAPS WITH 3/4-16 TAP TOP HOLE IN LINE WITH 9/16-18 TAP BOTTOM HOLE

RELEASED

2010-05-07

AM

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AS</i>	DRAWING NO.	
MFG. APPR.	<i>AS</i>	REV. E	
APPROVED	<i>AS</i>	D3262	
DE APPR.	<i>AS</i>	SHEET 2 OF 5	
DATE		TITLE	
10.05.03		SCALE	
NTS		FUEL PURGE CANISTER	

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NOTE: Date & initial all entries

8

7

6

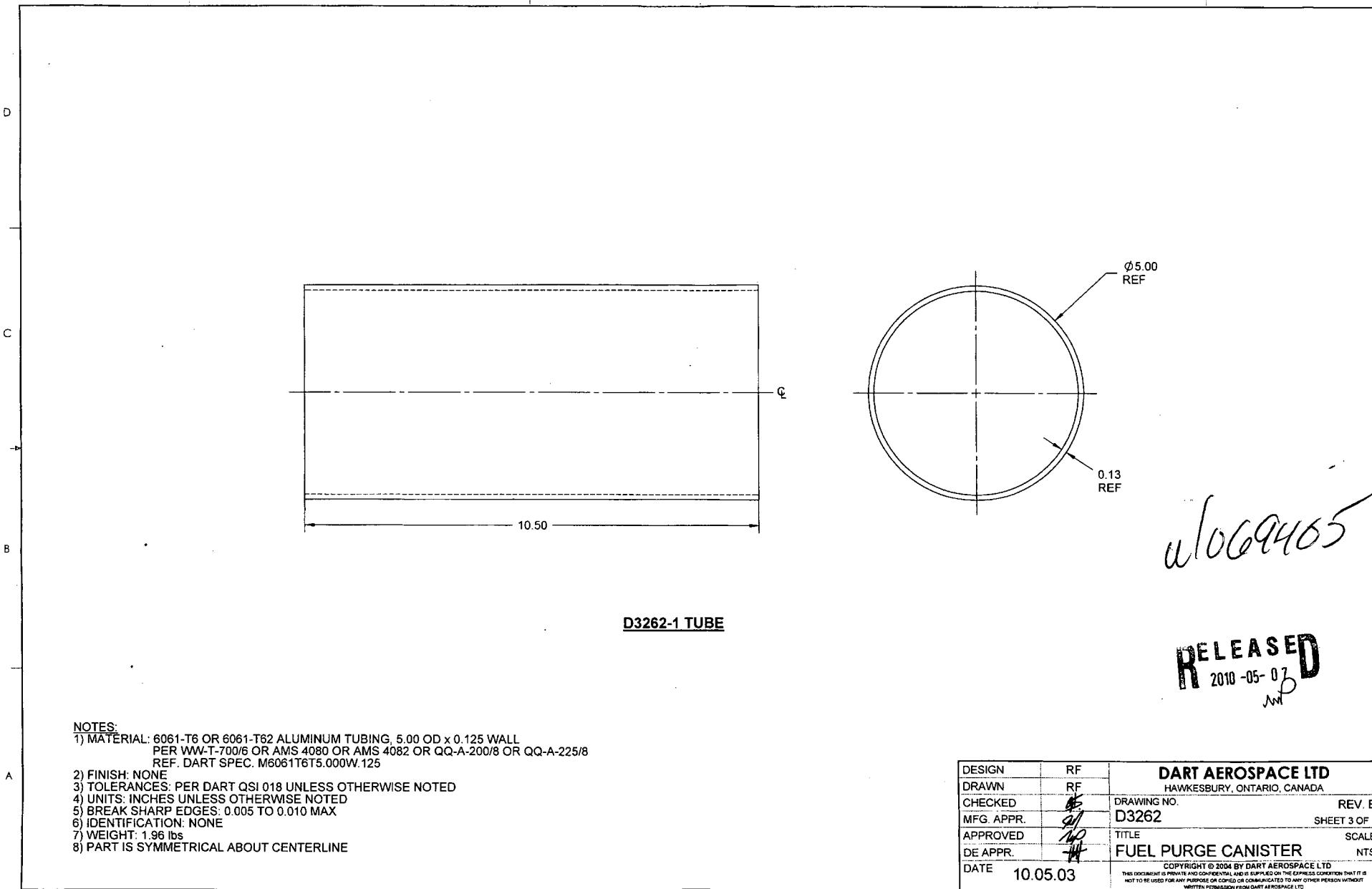
5

4

3

2

1



DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>AS</i>	DRAWING NO.
MFG. APPR.	<i>SI</i>	REV. E
APPROVED	<i>MP</i>	SHEET 3 OF 5
DE APPR.	<i>MP</i>	TITLE
DATE	10.05.03	SCALE
		NTS
		FUEL PURGE CANISTER

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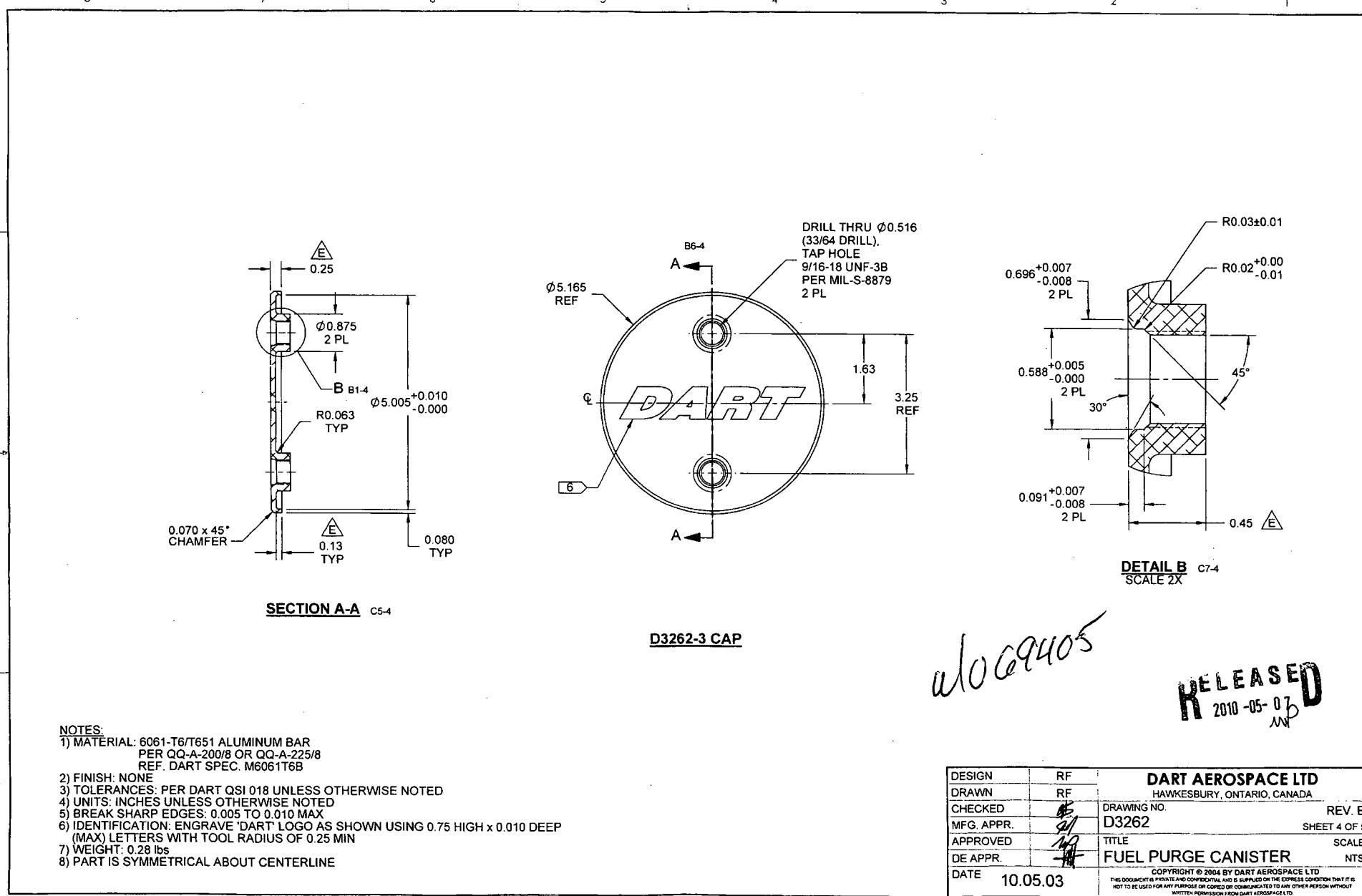
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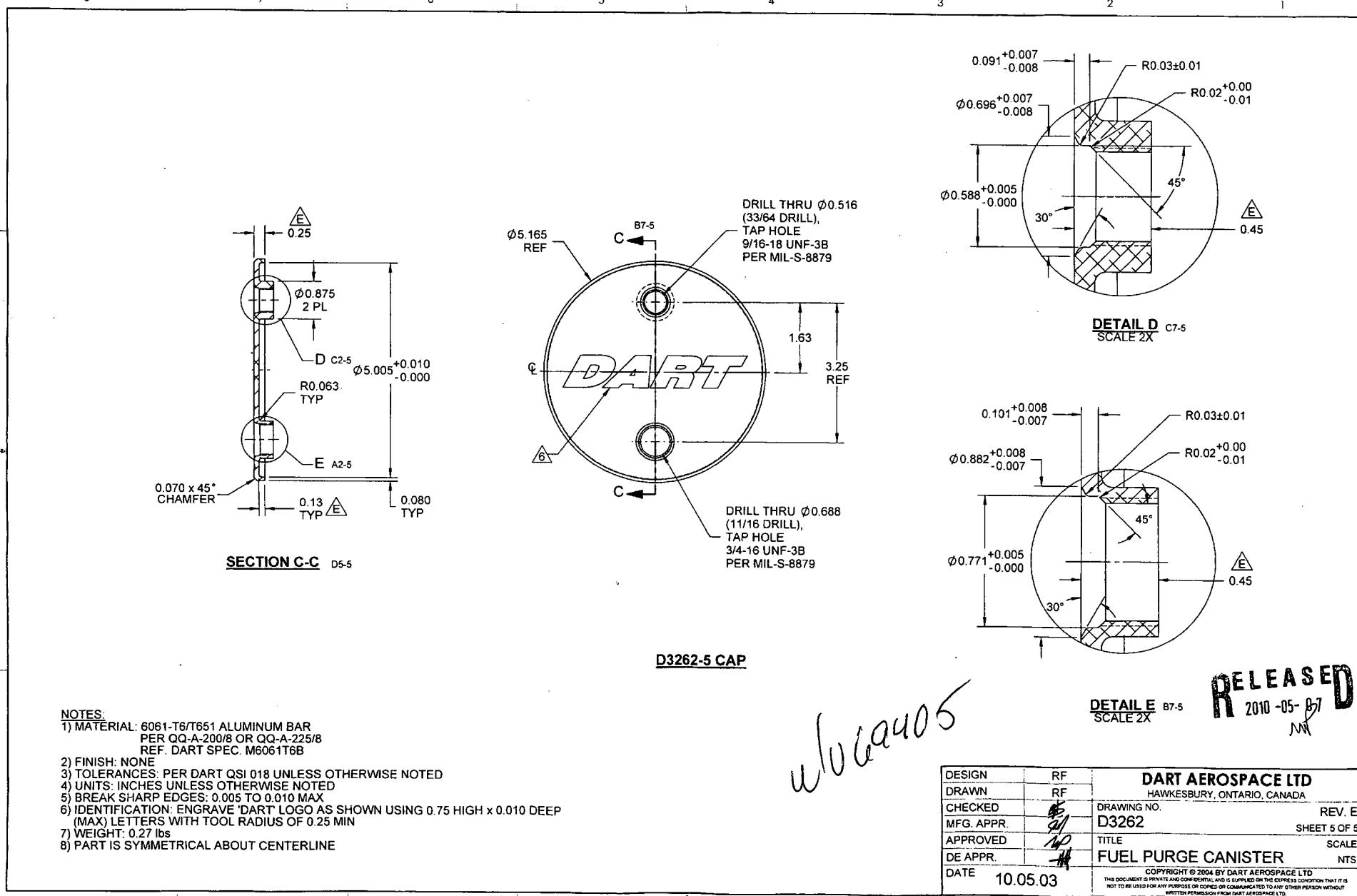


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